: LUG

: D22491

: N/A

D2249 REV. E

: 10/20/2007

Friday, 9/14/2007 2:00:49 PM

User

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 34671A

: 10839

P.O. Number

: NIA

This Issue

: 9/14/2007

S.O. No. : NA

Prsht Rev. First Issue

: NC : NA

: SMALL /MED FAB

: 34115 Previous Run

Written By

Checked & Approved By

Comment

Added Step 9 KJ/RF

Est Rev:E

Now on Waterjet 07-03-08 JLM

: Est: D 05:02.04

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 304/316 .063 Sheet

1.0

M304S16GA

Comment: Qtv.: 0.0903 sf(s)/Unit Total : 304/316 .063 Sheet

Batch: MIOS 130

路07-09-19

0.9030 sf(s)

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: E 18 07-09-19

Prog Rev:_____

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

Each

3.0

QC2



18 07-09-19

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

PACKAGING '

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock 5/122

Dart Aerospace Ltd

W/O:		WORK ORDER CH	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				18					
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A: <u></u>	<u> </u>	H/05/21		

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORI	DER NON-CONFORMANC	E (NCR)	Alexander all constraints		
		Description of NC		Corrective Action Section B		Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
					:			
				,				

NOTE: Date & initial all entries

Date:

Friday, 9/14/2007 2:00:49 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34671A

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



inspartion





Job Completion



U A.a.21

Dart Ae	rospace L	td			•					
W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	EP PROCEDURE CH		JRE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					i					
personal 14										
Part No	:	PAR #:	Fault Cate	gory:	NCR	R: Yes	No DQA		_ Date: _	·
						QA: N/	C Closed	:	_ Date: _	
NCR:			WORK ORDI	ER NON-CONFOR	RMANCE	(NCR))			
		Description of NC		Corrective Action	Section B		Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initial	Action Descripti	on	Sign &	Section		Approval Chief Eng	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
						·				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34671A
Description: Lug	Part Number:	D2249-1
Inspection Dwg: D2249 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

r**-						<u></u>
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.261	+0.006/-0.001	261	¥			
1.369	+/-0.010	1.369	*			
3.572	+/-0.010	3571	*			
0.13	+/-0.030	B	*			
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		277			_	
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	<u></u>		L			L

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Measured by:	IB	Audited by:	5			Prototype Approval:	N/A
Date:	07-69-19	Date:	8	109/21		Date:	N/A
					. –		

Rev	Date	Change	Revised by	Approyed
Α	07.03.23	New Issue	KJ/JLM	



		16	ns ^c	y	
Α	99.09.20	DATE	R	CHECKED	DESIGN
94.06.20			+	APPROVED	DRAWN BY
NEW ISSUE	FITTING	TITLE	D2249 SHEET 1 OF 4	DRAWING NO.	DART AEROSPACE LTD
	NTS	SCALE	1 OF 4	REV. E	



О

98.04.30

Ø0.261 WAS Ø0.257 REMOVED DUPLICATE

(TSR A179) DIMENSIONS

99.09.20

ADDED GUSSET

O æ

95.12.14

DIMENSION CHANGE

95.11.30

DIMENSION

CHANGE

D2249		249-3 (1)
D2249−1 (2)		
SHOP COPY WELD PER POWDER ALL DIMENSIONS SHOP COPY WELD PER POWDER FINISH: DIMENSIONS ON CONTROLLED COPY WELD COPY WITHOUT NOTICE WITHOUT NOTICE WORK ORDER ALL DIMENSIONS NO. 344634	D2249-041 ASSEMBLY 04/316 SS, 0.063 THICK QSI 004 COAT WHITE (4.3.5.2) PER DART QSI 005 ARE IN INCHES	1.3

E D2249-5 (REF)

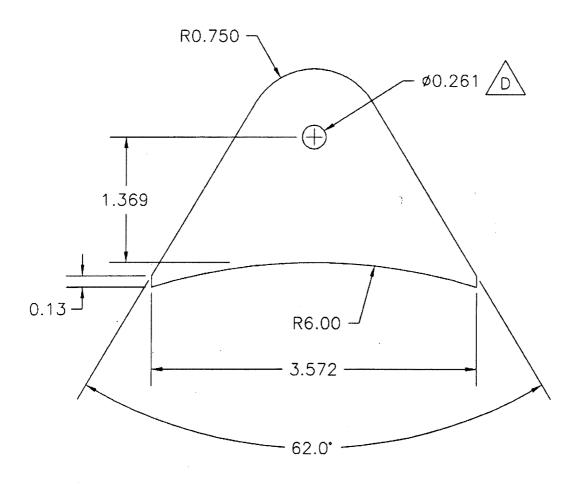
MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED





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I BE	 	D2249	SHEET 2 OF 4
DATE		TITLE	SCALE
99.09.20		FITTING	1:1





D2249-1 LUG

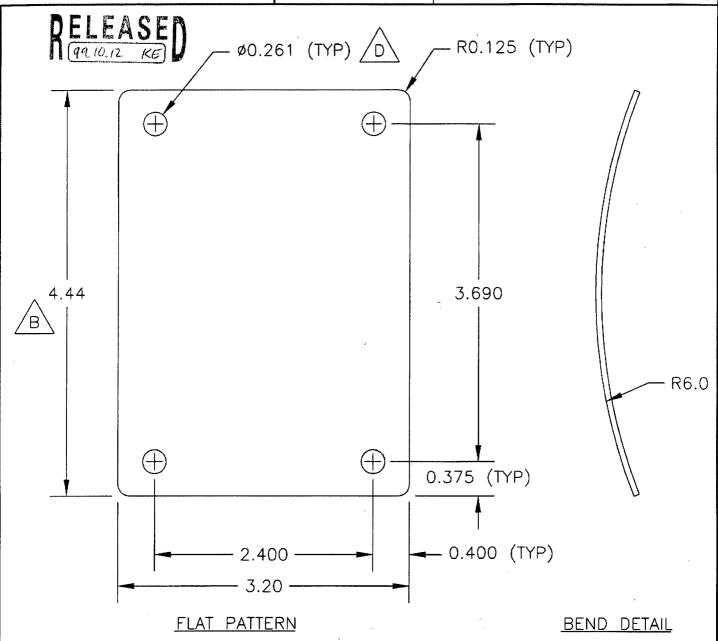
MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTEDWITHOUT NOTICE

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D2249-3 BASE PLATE

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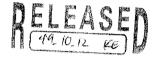
SUBJECT TO AMENDMENT WITHOUT NOTICE

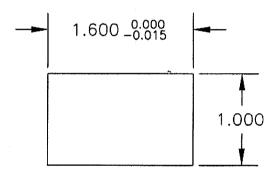
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER





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	DATE		TITLE	SCALE
	99.09.20		FITTING	1:1





D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

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